

Work Order ID 86095

86095

Page 1

Item ID: D3021-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Tube Assembly

Stop *NS2*

Start Date: 20/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/20* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3021	Rev A								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut tube as per Dwg D3021								
	2-Drill tube as per Dwg D3021 using D8622								
	3-Deburr								
	4-Weld as per Dwg D3021 QSI004								
	A/R 4130 Rod Batch: <i>M118825</i>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

0 *12-7-12*

1 0 *26/07/09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86095

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Item ID: D3021-041
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Item Name: Tube Assembly

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N900040100

Setup Start *NS1*
Stop *NS2*

Start Date: 20/06/2012 Start Qty: 1.00 *1*
Required Date: 04/07/2012 Req'd Qty: 1.00 *1*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

START TIME: 11:00

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:30

0.00

140 QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

IX ✓ M-L 12/07/10

1 ✓ BY 12-7-10

M12127a

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Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: GA

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 12/07/10

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Picklist Print

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Page 1

Work Order ID: 86095

86095

Parent Item: D3021-041

D3021-041

Parent Item Name: Tube Assembly

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP 01.10.23 New Issue SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3017-11		Manufactured	No			100	Each	50.0000	2	2			

D3017-11

cap

**

12-7-12

Location

WA021

76831

Loc Qty

50

50

Loc Code

M4130NT0.750W.049

Purchased

No

100

f

105.9200

2.0833

2.192947

**

12-7-12

M4130NT0 750W 049

4130 RD Tube .750 x.049W

Location

MAT033

120350

121025

Loc Qty

105.92

65.61

40.31

Loc Code

2-19

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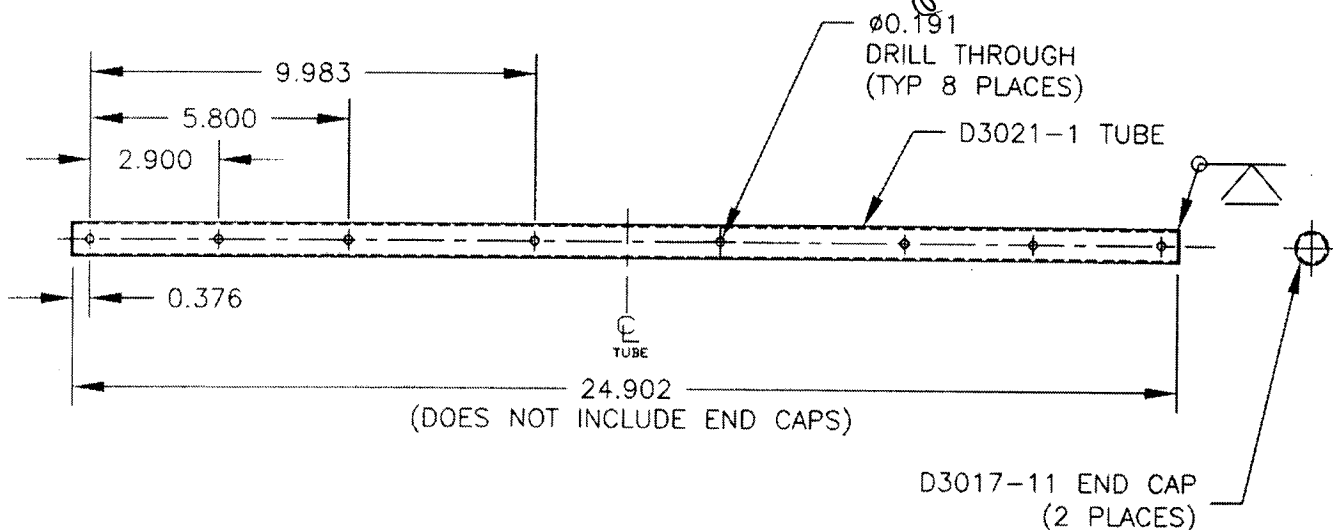
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80025 MCV
12/06/20



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, $\phi 0.75$ DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30

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